

Date: Friday, 7/21/2006 1:55:02 PM  
User: Kim Johnston

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : 205 SKIDTUBE "I" BEAM
<b>Job Number</b> : 28025	
<b>Estimate Number</b> : 10346	
<b>P.O. Number</b> : N/A	<b>Part Number</b> : D2596
<b>This Issue</b> : 7/21/2006 <b>S.O. No.</b> : N/A	<b>Drawing Number</b> : D2596 REV C
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : N/A <b>Type</b> : LANDING GEAR	<b>Drawing Revision</b> : C
<b>Previous Run</b> : 27655	<b>Material</b> : N/A
<b>Written By</b> : <u>See Comment Below</u>	<b>Due Date</b> : 7/31/2006
<b>Checked &amp; Approved By</b> : <u>06.07.21</u>	<b>Qty:</b> 12 <b>Um:</b> Each
<b>Comment</b> : Est: D 99.02.02 Changed QA to QC, Added Step 6 and Cost D M	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	D25003100	Ext'n -I' Beam Web 4"
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)

Extrusion "I" Beam Web 4"

Pick;

Qty	Part Number	Description	Batch
1	D2500-3-100	Extrusion	025751

Batch

025751

25 06-08-11 (12)

2.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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**Comment:** LANDING GEAR RESOURCE 1

1- Cut D2500-3-100 to length: 99.5"

25 06-08-11 (12)

2- Use Jig DT8093 to drill pilot holes #30

25 06-08-14 (12)

3- Open to 0.625" diameter using a uni-bit

25 06-08-14 (12)

4- Deburr

25 06 08 14 (12)

3.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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**Comment:** HAND FINISHING RESOURCE #1

Acid Etch and Alodine per QSI 005 4.1

IT 06-08-14 (12)

4.0	QC5	INSPECT WORK TO CURRENT STEP
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**Comment:** INSPECT WORK TO CURRENT STEP

Pm 06-08-14 (12)

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1

Identify and Stock

Location: LG

Pm 06-08-14 (12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: SD Date: 06/08/15

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Date: Friday, 7/21/2006 1:55:03 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 205 SKIDTUBE "I" BEAM

Job Number: 28025

Part Number: D2596

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SD 06/08/15 (12)

Job Completion



U 06/08/15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

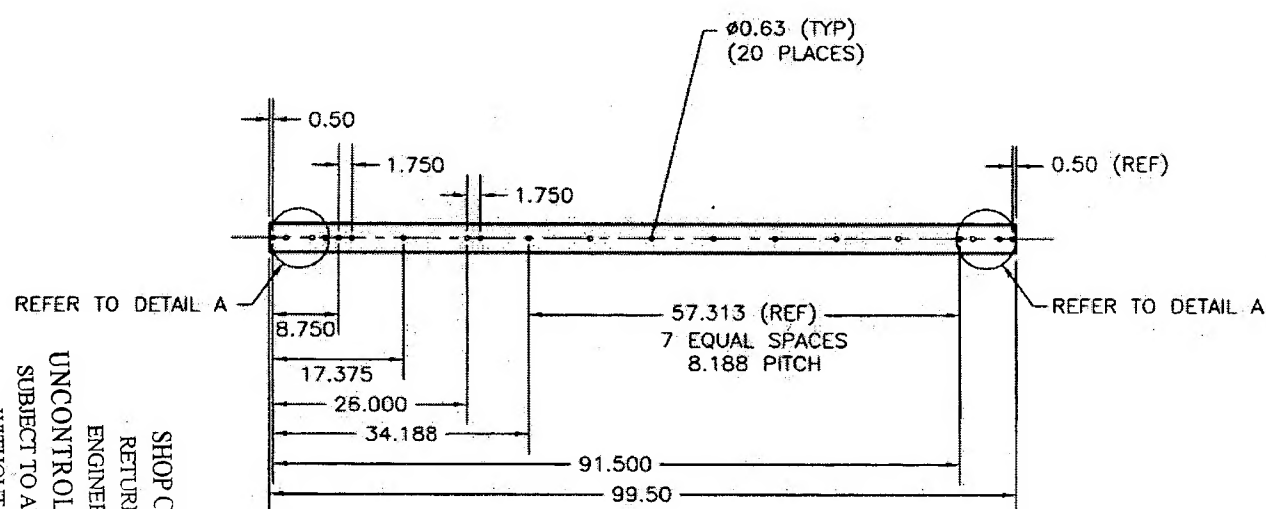
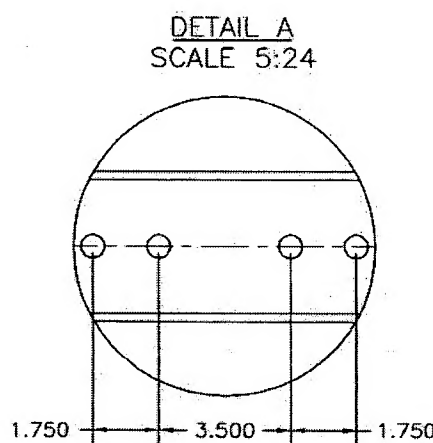
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

**DART**



**RELEASED**  
18.09.17 b5

DESIGN	DRAWN BY	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	REV. C
CHECKED	APPROVED	DRAWING NO. D2596	SHEET 1 OF 1
DATE 98.09.14	TITLE 205 WEB	SCALE 1:24	
A	96.09.16	NEW ISSUE	
B	97.07.23	Ø0.63 HOLE WAS Ø0.56	
C	98.09.14	INCORPORATED DEC 9097	



MANUFACTURED FROM D2500-3 EXTRUSION  
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
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WITHOUT NOTICE

WORK ORDER  
NO. 28025